

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026534**Date Inspected:** 14-Oct-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1800**Contractor:** Watson Bowman ACME**Location:** Buffalo, NY**CWI Name:** Reno Davis, John Crabtree**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date, Quality Assurance Inspector (QAI) Kenneth Riley was present at the Watson Bowman Acme Corporation (WBA) facility, as requested, in Buffalo, New York to observe fabrication activities of the Seismic Expansion Joint Hinge A lanes for the San Francisco Oakland Bay Bridge (SFOBB) project.

This (QA) Inspector met with Watson Bowman Acme Corporation (WBA) Quality Control (QCS) Supervisor John Miller and KTA-Tator (ABF Representative), Certified Welding Inspectors (CWI), Reno Davis Day Shift, and Mr. John Crabtree night shift. ABF Representatives are the Quality Control personnel for this location.

This QAI arrived at WBA and met with Greg Ross the QCM to discuss the status of the outstanding Request For Information (RFI) and submittals. Mr. Ross stated that he would be sending out the RFI's today to ABF so they could be forwarded to Caltrans. The issues are for misalignment of CA3-1, Single pass fillet weld soundness test, WPS for the double bevel PJP weld, and the base metal repair procedure. This QAI spoke to Mr. Ross concerning this due to these issues have been open for at least 1~2 weeks with no submittals sent. This QAI informed Mr. Ross that it is imperative to resolve these issues and move forward with the project so as to not incur delays. This QAI and ABF representative Reno Davis travelled to Private Systems in Blasdell, NY to observe the machining of the top plates due to the 39.5mm holes had been burned by Samuels Steel (WBA's vendor). Upon arrival this QAI met with Mr. Craig Bridges who informed him that the 16 plates had been picked up by Samuels that morning and the milling had been completed. Upon returning to WBA it was observed that the plates had arrived and the burned holes had been milled using a "corn cob" attachment as to keep the centerline of the hole true. During this observation this QAI observed that the milling process left a threaded appearance within each hole and you could still see the flame cutting scarf's in some of the holes after the milling process. WBA QCM

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# WELDING INSPECTION REPORT

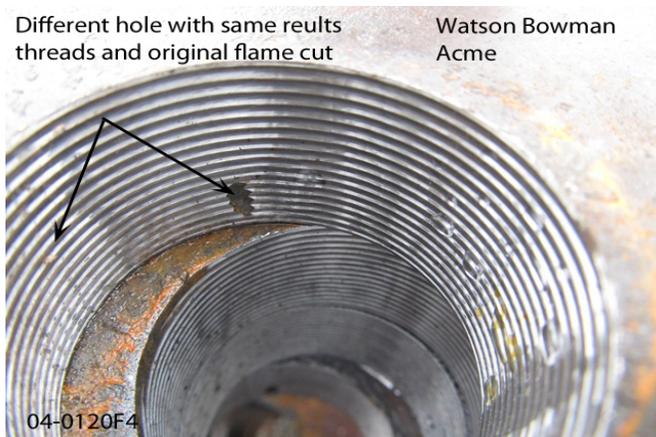
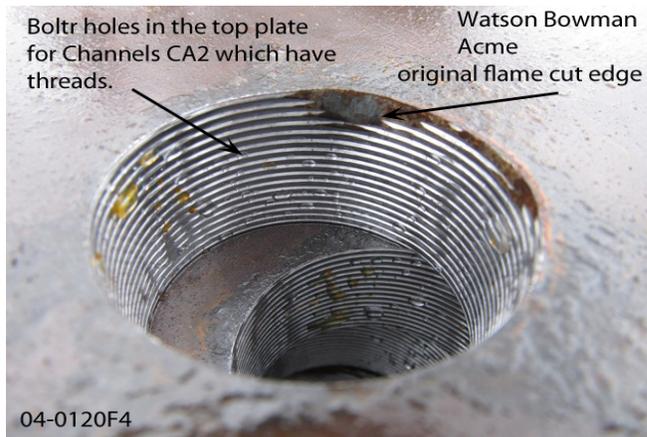
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Greg Ross asked if it would be easier to just reject all 16 plates and start over, this QAI informed Mr. Ross that this QAI could not direct him in what to do with the material that it was their decision as to what direction to take to resolve this issue. This information has been forwarded to the Structural Material Representative (SMR) for resolution. (See attached photos)

No welding was observed on the day or night shift.



## Summary of Conversations:

Basic conversation, fundamental to completion of the tasks at hand, occurred between this QAI, ABF QC, and WBA personnel .

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

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**Inspected By:** Riley, Ken

Quality Assurance Inspector

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**Reviewed By:** Levell, Bill

QA Reviewer